



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

D3560-041
Job Sheet 175946



Part No: D3560-041

Job Qty: 2 ea

Part Name: Arm Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 5/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A New Issue 07.05.24 EC IPP rev B ECN 987 07.10.09 EC verified by: DD IPP Rev:C
ECN1048 07-12-18 DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		5/19/18	0.00	0.00	Start Up Large Fab-4		MS 2018-05-07
140	Large Fab	2 pcs		5/19/18	0.00	1.63	Large Fab 2		15-5-8
150	QC	2 pcs		5/19/18	0.00	0.00	QC5		CPC
160	QC	2 pcs		5/19/18	0.00	0.00	QC9		CPC
170	HandFinish	2 pcs		5/19/18	0.00	0.25	HandFinish1		BEB 18-05-09
180	QC	2 pcs		5/19/18	0.00	0.00	QC7-2		CPC
190	Small Fab	2 pcs		5/21/18	0.00	0.06	Small Fab-4		D.M.L
200	QC	2 pcs		5/21/18	0.00	0.00	QC5		CPC
210	Packaging	2 pcs		5/21/18	0.00	0.00	Packaging3-1		D.M.L
220	QC21-SA	2 Ea		5/21/18	0.00	0.00	QC21		21 MAY 10 2018

Part Op 140 - 1-Weld assembly as per dwg D3560 STEP: 1- clean material (buff bracket and bottom of arm with blue pad) 2- set
Descriptions: up bracket and arm on jig 3- preheat bracket and arm with torch 4- clean before welding with brush 5- set up machine to
135 amps 6- weld across bottom and top ends 7- reheat with torch (65 deg C) 8- on one side weld from bottom to top
half way 9- same for other side (half way) 10- from half way point weld the rest of the first side (ease off pedal near end)
11- same for remaining side (ease off pedal near end)

190 - 1-Press bushing in D3560 arm per dwg D3562

210 - *** STOCK IN STEP CELL*** LOCATION: WA003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3560-1	Arm	2 Ea (1 ea)	90-Start up Operation	5052472
D3592-1	Plate	2 Ea (1 ea)	90-Start up Operation	50163834
D2808	Spacer	2 Ea (1 ea)	190-Small Fab	B155607

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3560-1	2	6	0
	D3592-1	2	20	0
190-Small Fab	D2808	2	18	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
Root Cause				FAULT CATEGORY																																																											
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	
		Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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Date: 05/07/10



Container No: S069162

Part: D3560 - 041

Job No: 175946

Serial No/Batch: S069162

Revision:

Inspector:

JLT CATEGORY

Inqualified	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Unclear	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence